

nylon, polyvinylidene chloride-coated biaxially oriented nylon, oriented polypropylene and polyvinylidene chloride-coated oriented polypropylene, wherein said first layer has said first laser-scored pattern etched therein.

33. (New) The flexible film of claim 32 wherein said first layer forms an outer layer of said flexible film.

34. (New) The flexible film of claim 32 further comprising:

a second layer comprising a material selected from the group consisting of adhesive and polyolefin.

35. (New) The flexible film of claim 34 wherein said second layer does not have the first laser scored pattern etched therein.

36. (New) The flexible film of claim 31 further comprising:

a first layer comprising a material selected from the group consisting of ethylene vinyl alcohol copolymer, polyvinylidene chloride-methyl acrylate copolymer, nylon, metal foil, and metallized film.

37. (New) The flexible film of claim 36 wherein said first layer forms a barrier layer of said flexible film.

38. (New) The flexible film of claim 31 wherein said first laser scored pattern comprises a first portion that is straight and parallel to an edge of said flexible film wherein said edge runs in the machine direction.

39. (New) The flexible film of claim 31 wherein said first laser scored pattern comprises a first portion and a second portion, wherein said first portion is displaced from said second portion in the transverse direction of said surface of said flexible film.

40. (New) The flexible film of claim 31 wherein said first laser scored pattern comprises a recurring pattern in the machine direction of said surface of said flexible film.

41. (New) The flexible film of claim 39 wherein said first portion is a straight line disposed in the machine direction of said surface of said flexible film.

42. (New) The flexible film of claim 39 wherein said first portion and said second portion form a continuous score line.

43. (New) The flexible film of claim 39 wherein said second portion is displaced toward a first edge of the flexible film relative to said first portion.

44. (New) The flexible film of claim 31 further comprising:

a recurring symbol on said surface of said flexible film for indicating where to apply said first laser-scored pattern on said face of said flexible film.

45. (New) The flexible film of claim 31 further comprising:

a second laser-scored pattern on said surface of said flexible film wherein said second laser-scored pattern is disposed in said machine direction and said transverse direction of the surface of the flexible film and further wherein said second laser-scored pattern forms a second line of weakness in said flexible film.

46. (New) The flexible film of claim 45 wherein said first laser-scored pattern is disposed proximate a first edge of said flexible film and further wherein said second laser-scored pattern is a mirror image of said first laser-scored pattern and further wherein said second laser-scored pattern is disposed proximate a second edge of said flexible film.

47. (New) The flexible film of claim 31 wherein said first line of weakness in said flexible film has a tensile strength measured across said line of weakness of between about 3 lb/in. and about 10 lb/in.

48. (New) The flexible film of claim 47 wherein said first line of weakness in said flexible film has a tensile strength measured across said line of weakness of about 6.5 lb/in.

49. (New) The flexible film of claim 31 further comprising:

an outer layer of said flexible film comprising a material selected from the group consisting of polyethylene terephthalate, biaxially oriented nylon, and oriented polypropylene; and

a barrier layer within said flexible film comprising a material selected from the group consisting of ethylene vinyl alcohol copolymer, polyvinylidene chloride-methyl acrylate copolymer, nylon, metal foil and metallized film.

50. (New) The flexible film of claim 31 further comprising:

a first film structure comprising an outer layer comprising a material selected from the group consisting of polyethylene terephthalate, biaxially oriented nylon and oriented polypropylene;

a second film structure comprising a second film structure comprising a barrier layer comprising a material selected from the group consisting of ethylene vinyl alcohol copolymer, nylon, polyvinylidene chloride-methyl acrylate copolymer, foil, and metallized film,

wherein said first film structure is laminated to said second film structure with a material selected from the group consisting of adhesive and polyolefin.

51. (New) A method of making a laser-scored flexible thermoplastic polymeric film comprising the steps of:

forming a multilayer web wherein said web has a surface and further wherein said surface comprises a coordinate system having a machine direction parallel to edges of the web and a transverse direction perpendicular to said machine direction; and

scoring said surface of said web with a focused laser beam in both the machine direction and the transverse direction to form a first laser-scored pattern thereby forming a first line of weakness in said face of said flexible film.

52. (New) The method of claim 51 further comprising the step of:  
coextruding said multilayer web.

53. (New) The method of claim 51 further comprising the step of:  
laminating the layers of said multilayer web together.

54. (New) The method of claim 51 further comprising the step of:  
extrusion laminating the layers of said multilayer web together.

55. (New) The method of claim 51 further comprising the steps of:  
extruding the layers of said multilayer web; and  
adhesive laminating the layers of said multilayer web together with an adhesive.

56. (New) The method of claim 51 further comprising the steps of:  
moving said multilayer web in said machine direction; and

scoring said surface of said web with said focused laser beam while said web is moving in said machine direction.

57. (New) The method of claim 51 wherein said web comprises a first layer comprising a material selected from the group consisting of polyethylene terephthalate, polyvinylidene chloride-coated polyethylene terephthalate, biaxially oriented nylon, polyvinylidene chloride-coated biaxially oriented nylon, oriented polypropylene and polyvinylidene chloride-coated oriented polypropylene.

58. (New) The method of claim 57 further comprising the step of:  
forming an outer layer of said flexible film with said first layer.

59 (New) The method of claim 51 further comprising the step of:

coextruding said multilayer web wherein said web comprises a first layer comprising a material selected from the group consisting of ethylene vinyl alcohol copolymer; polyvinylidene chloride-methyl acrylate copolymer, nylon, metal foil and metallized film.

60. (New) The method of claim 59 further comprising the step of:  
forming a barrier layer within said flexible film with said first layer.

61. (New) The method of claim 56 further comprising the step of:  
actuating said laser beam in the transverse direction while the web is moving in the machine direction to score the first laser-scored pattern in the surface of the web in both the machine direction and the transverse direction of the face of the web.

62. (New) The method of claim 61 wherein said laser beam is actuated in the transverse direction to score the first laser-scored pattern in the surface of the web in both the machine direction and the transverse direction without refocusing the laser beam while actuating the laser beam.

63. (New) The method of claim 51 wherein said first line of weakness has a tensile strength measured across said first line of weakness of between about 3 lb/in. and about 10 lb/in.

64. (New) The method of claim 63 wherein said first line of weakness has a tensile strength measured across said first line of weakness of about 6.5 lb/in.

65. (New) The method of claim 51 further comprising the step of:  
scoring said surface of said web in both the machine direction and the transverse direction with a second focused laser beam to form a second laser-scored pattern thereby forming a second line of weakness in said surface of said web.

66. (New) The method of claim 65 further comprising the step of:  
moving said multilayer web in said machine direction;  
scoring said surface of said web with said first and second laser beams while said web is moving in said machine direction.

67. (New) The method of claim 65 further comprising the steps of:  
scoring said first line of weakness in said surface of said web proximate a first edge of said web; and

scoring said second line of weakness in said surface with said second laser beam proximate a second edge of said web.

68. (New) The method of claim 65 wherein said second laser-scored pattern is a mirror image of said first scored pattern.

69. (New) The method of claim 51 further comprising the steps of: